

Work Order ID 58661

Thursday, May 13, 2010 10:28:09 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *10-5-13* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	A								
100	Weld per dwg A/R S.S. rod Batch: <i>111679</i>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

Cpl 10-05-25

ID 10-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ES 10/05/26 @

160



Packaging

Packaging

Identify as per dwg & Stock Location *G-A*

0.00

Memo

0.00

w/o
BS8777

ES 10/05/26 @

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/26 @

C21015126

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Picklist Print

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Work Order ID: 58661

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC


Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00


Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	36.0000	2			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code


WA	36	
46086	2	
51745	2	
57185	9	
58301	23	

D2728-3  Dart Logo label		Manufactured	No			140	Each	0.0000	1			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

D3914-1  Rib		Manufactured	No			100	Each	6.0000	2			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Location Loc Qty Loc Code

WA	6	
58241	2	
58585	4	

D3914-7  Rib		Manufactured	No			100	Each	4.0000	2			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Location Loc Qty Loc Code

WA	4	
58242	4	

B58707 → 2

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Page 2

Work Order ID: 58661

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)









Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3		<i>Pl 10.05.21</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST109		7				<i>58595</i>	<i>→ ①</i>	
				57574		7						
				ST116		12						
				58243		12				<i>②</i>		
D4018-5  Rib		Manufactured	No			100	Each	12.0000	9		<i>Pl 10.05.21</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		12				<i>B58977</i>	<i>→ ⑦</i>	
				58244		12						
D4020-5  Mesh (350 Basket Long, Lid)		Manufactured	No			100	Each	2.0000	1		<i>Pl 10.05.25</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2				<i>B58691</i>	<i>→ ①</i>	
				58245		2						
D4021-3  Data Plate		Manufactured	No			100	Each	3.0000	1		<i>Pl 10.05.28</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		3				<i>B58875</i>	<i>→ ①</i>	
				56050		1						
				58246		2						

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Shop Packet Print

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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4035-041



Lid Rib Assembly, Fwd (350 Basket)

Manufactured

No

100

Each

2.0000

1

Location

Loc Qty

Loc Code

WA

2

58192

2

D4035-043



Lid Rib Assembly, Aft (350 Basket)

Manufactured

No

100

Each

2.0000

1

Location

Loc Qty

Loc Code

WA

2

58193

2

D4086-210



Placard, Max Load

Manufactured

No

140

Each

4.0000

1

Location

Loc Qty

Loc Code

ST112

4

56978

4

~~B58739~~

B58926



B 58743

Pl 10.05.21

①



B 58744

Pl 10.05.21

①



2

80 08/05/26

①

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Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

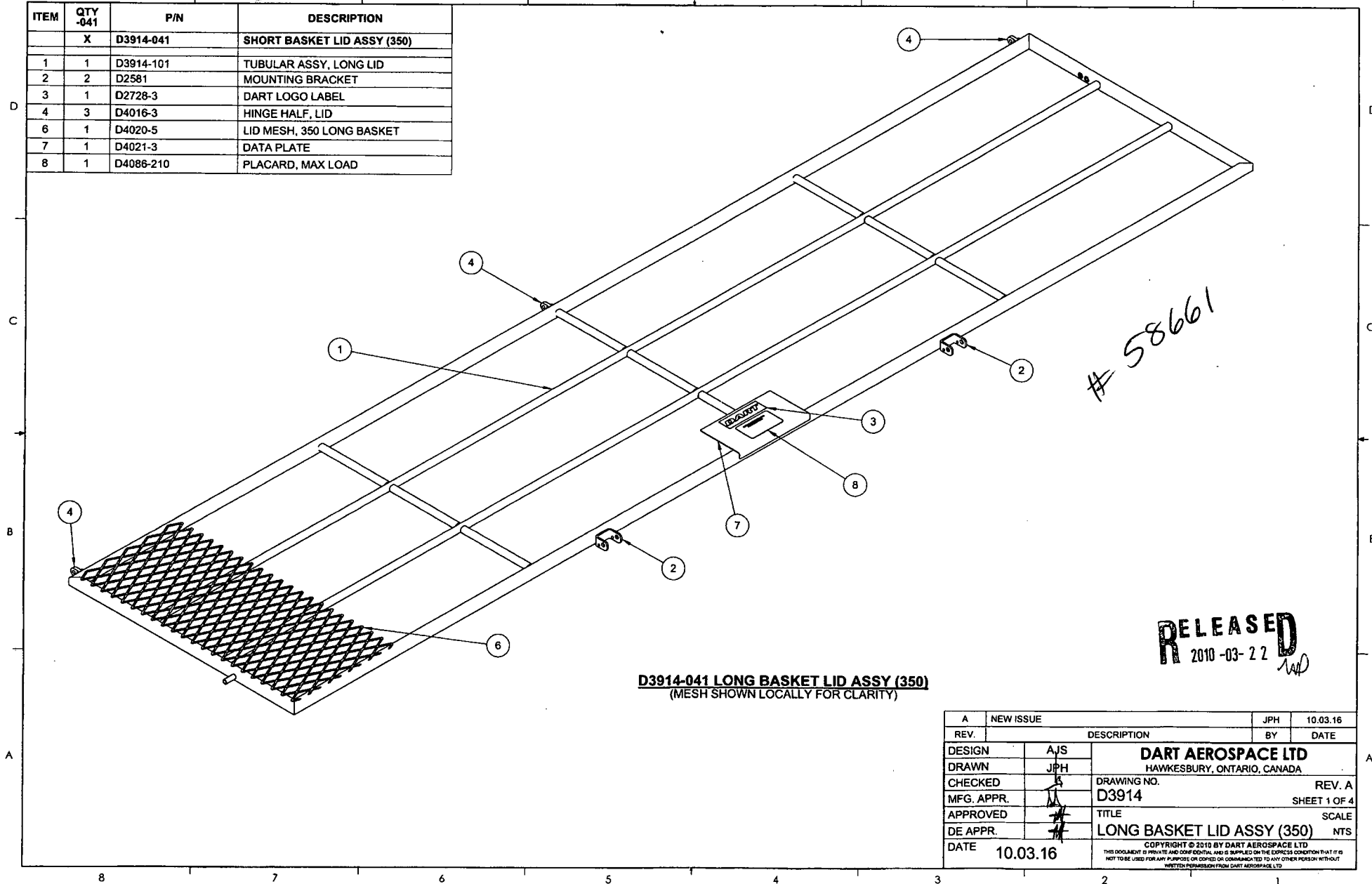
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-22

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3914	SHEET 1 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

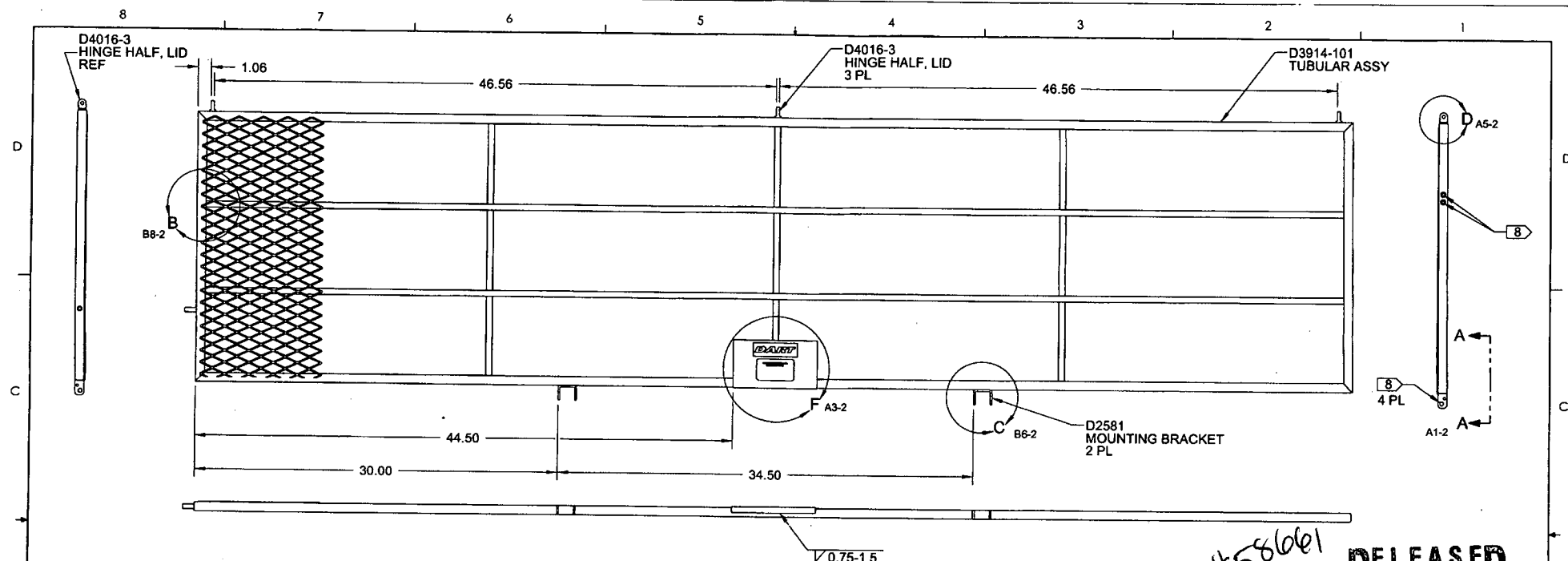
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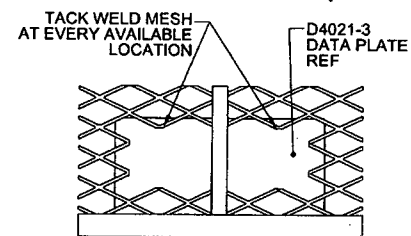
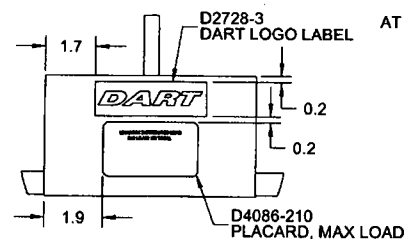
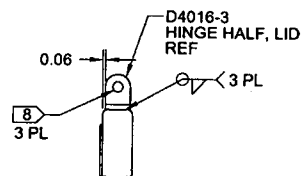
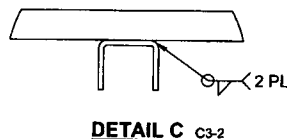
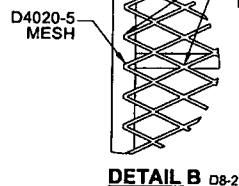
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NOTE: Date & initial all entries



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-22

#586061

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

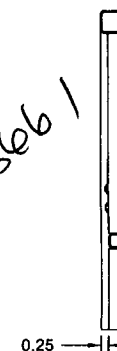
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

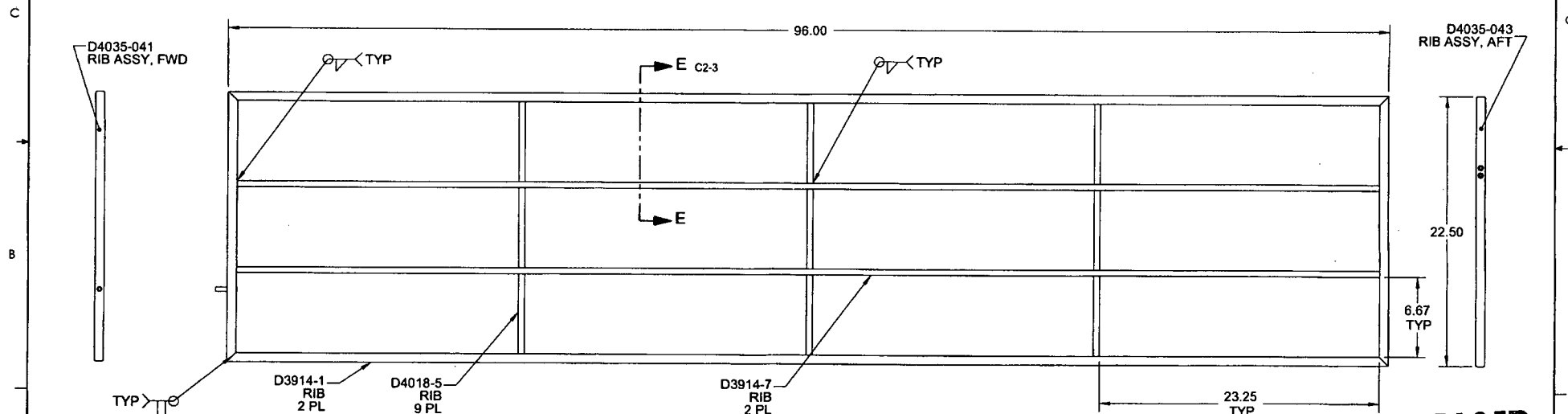
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
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RELEASED
2010-03-22
AWP

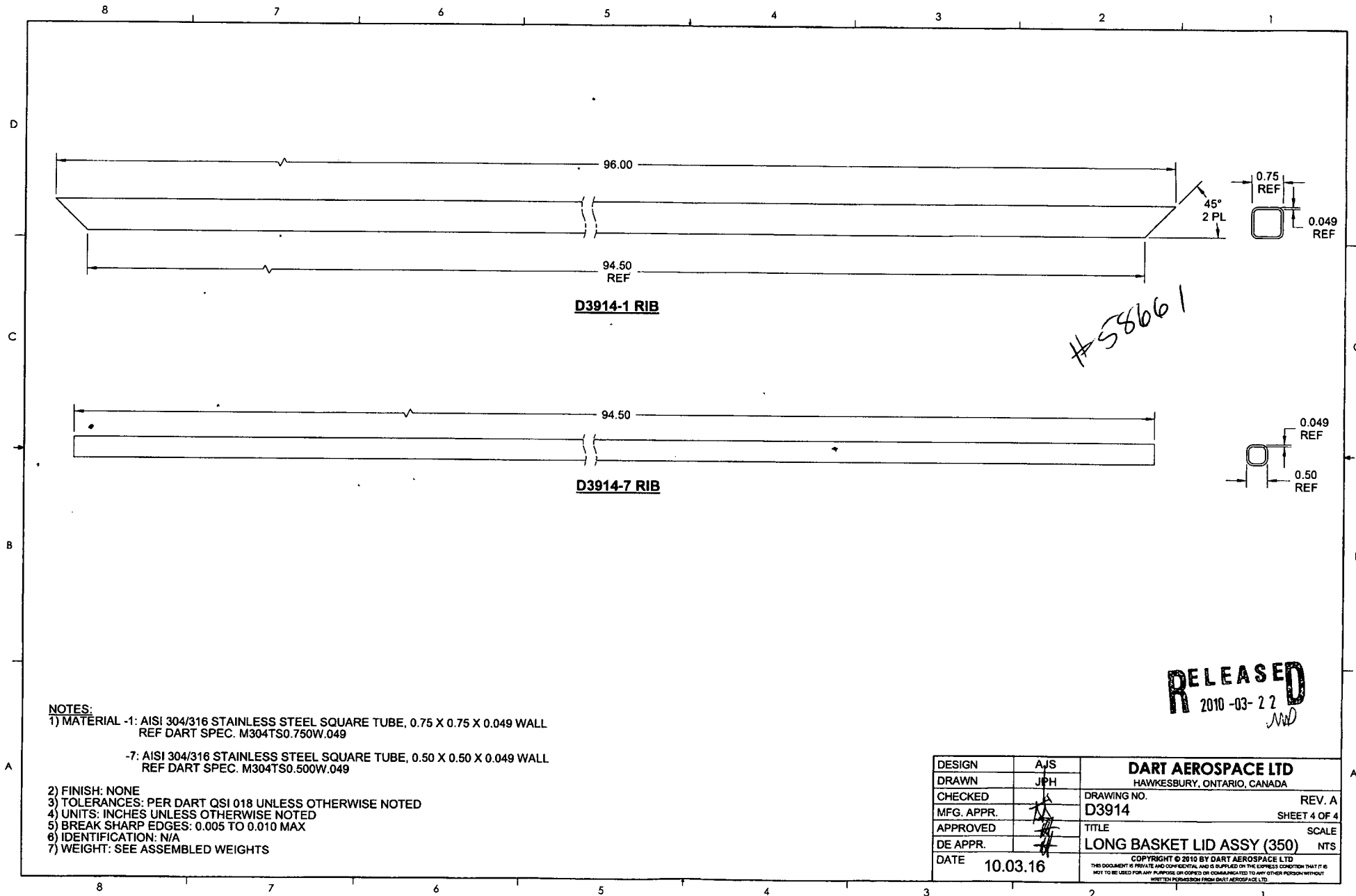
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